

Work Order ID 79469

79469

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January-26-12 1:05:50 PM

Item ID: D2174-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web
 Start Date: 26/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.C.S Date: 12/01/2012 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2174	Rev E

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00 HB B12-4-12
 FLOW CNC Waterjet 1-Cut as per Dwg D2174 Dwg Rev: E Prog Rev: F 2-
2024.063 Deburr if necessary 8

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 B12-4-12
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 8/26/13 78
 Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

79469

January-26-12 1:05:50 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Web

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): / Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Small Fab

Small Fab

Small Fab

Memo

Deburr Stack

0.00

0.00

0.00\

0.00

140

140

OC

Quality Control

QC5- Inspect part completeness to step on ~~Y~~/O

Memo

150

150

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

8 767 124 = 16

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Dart Aerospace Ltd

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Picklist Print

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Page 1

Work Order ID: 79469

79469

Parent Item: D2174-1

D2174-1

Parent Item Name: Web

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP C04.06.09ReformatKJ/RF

IPP Rev:D As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

217.0000

0.4722

1.988211

4,

M2024T3S 063

**

B12-472

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

217

117392

25

119916

192

~~117392~~
119916

8

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DART AEROSPACE LTD		Work Order: 79469
Description: Web		Part Number: D2174-1
Inspection Dwg: D2174	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.250	+/-0.010	6.262	2		V RB02	
6.400	+/-0.010	6.401	2		V	
4.800	+/-0.010	4.811	2		V	
1.375	+/-0.010	1.383	2		V	
1.050	+/-0.005	1.051	2		V	
Ø0.128	+0.005/-0.001	.129	2		V	
12.650	+/-0.010	12.650	2		T RB01	
0.550	+/-0.010	.552	2		V	
0.900	+/-0.010	.902	2		V	
1.629	+/-0.010	1.625	2		V	
1.506	+/-0.005	1.504	2		V	
11.550	+/-0.005	11.550	2		T	
50°	+/-0.5°	50°	2			
0.063 thick	+/-0.010	.063	2		✓	
Ø0.172	+0.005/-0.001	.171	2		✓	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-4-12	Date: 12/04/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.04.02	Ø0.172 dimension added	KJ/JLM	

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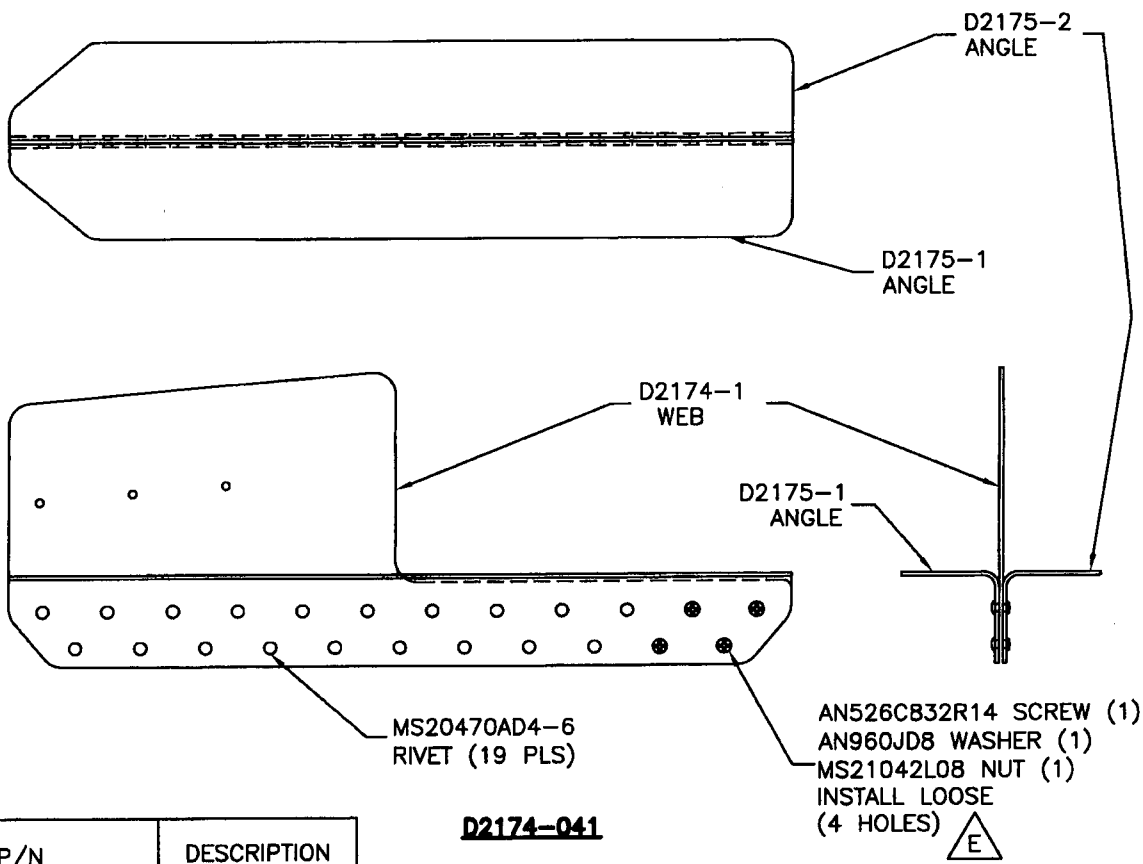
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
RF	CE		
CHECKED PH	APPROVED CE	DRAWING NO. D2174	REV. E
DATE 06.09.25		TITLE WEB ASSEMBLY	SHEET 1 OF 2
		SCALE 1:3	
A	95.10.25	NEW ISSUE	
B	96.01.18	RE-DRAWN	
C	00.09.11	UPDATE FINISH SPEC.	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE	



D2174-041

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

- NOTES:
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RELEASED
06.10.13

UNCLASSIFIED
SUBJECT TO REVIEW
79469 MCT
12/01/26

Dart Aerospace Ltd

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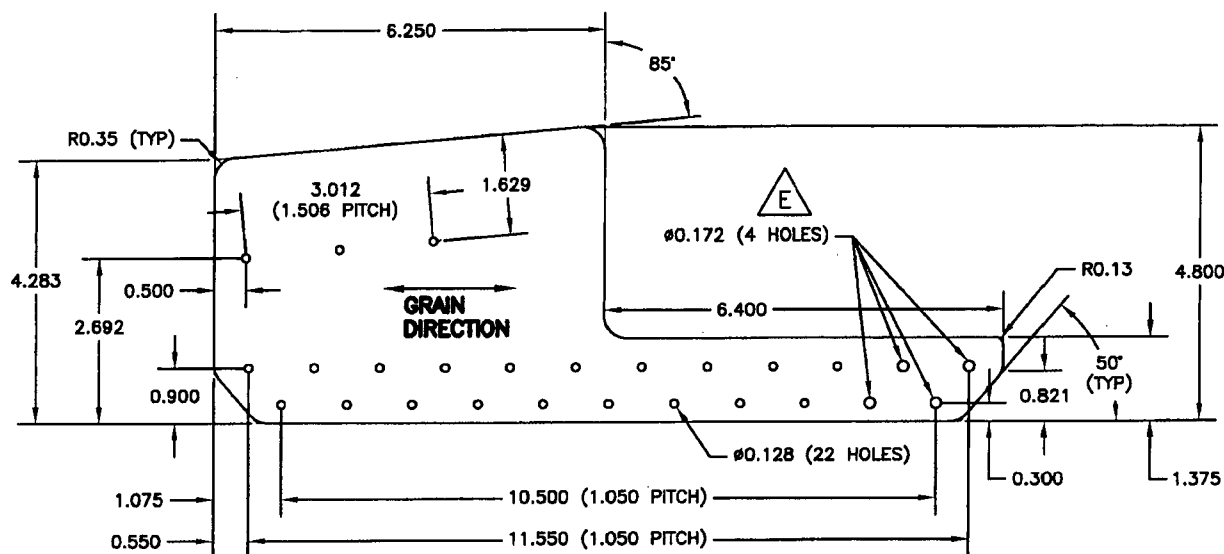
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DART

DESIGN	RF	DRAWN BY	CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
CHECKED	PH	APPROVED	[Signature]	DRAWING NO. D2174	SHEET 2 OF 2
DATE	06.09.25	TITLE	WEB	SCALE	1:3



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

RELEASED
06.10.13

Dart Aerospace Ltd

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